

Work Order ID 163130

Friday, June 30, 2017 7:37:29 AM

163130

Page 1

Item ID: D5383-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Tee

Start Date: 6/30/2017 Start Qty: 15.00

15

Cust Item ID:

Required Date: 7/13/2017 Req'd Qty: 15.00

15

Customer:

Reference: REWORK PER ECN17-588

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D5383

B

101

101

QC

Quality Control

Memo

PULL FROM STOCK:
15 X D5383-1 B151827
FOR REWORK PER ECN17-588ADD 2 X D5383-1 B
TO REWORK FROM W/O 162057

105

105

HAAS 5 AXIS

HAAS CNC vertical machine #5

Memo

REWORK PER ECN17-588 TO NEW REV

Work Order ID 163130***163130***

Page 2

Friday, June 30, 2017 7:37:29 AM

Item ID: D5383-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Tee
Start Date: 6/30/2017 Start Qty: 15.00 ***15*** Cust Item ID:
Required Date: 7/13/2017 Req'd Qty: 15.00 ***15*** Customer:
Reference: REWORK PER ECN17-588

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
108 *108* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				_____	_____	_____	_____
111 *111* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				_____	_____	_____	_____
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo RE-IDENTIFY USING NEW B/N AND NEW REV	0.00 0.00				_____	_____	_____	_____

163130

Friday, June 30, 2017 7:37:29 AM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 6/30/2017 **Start Qty:** 15.00

15

Cust Item ID:**Required Date:** 7/13/2017 **Req'd Qty:** 15.00

15

Customer:

Reference: REWORK PER ECN17-588

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number**Insp.
Stamp**

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

Picklist Print

Page 1

Friday, June 30, 2017 7:37:26 AM

Work Order ID: 163130

163130

Parent Item: D5383-1

D5383-1

Parent Item Name: Tee

Start Date: 6/30/2017

Required Date: 7/13/2017

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP REV:A 16.01.21 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5383-1		Manufactured	No				Each	0.0000		15			
D5383-1									**				

Tee

+2 from D39-799-039 w/0163057

List Lots

Thursday, June 22, 2017 7:17:42 AM

Page 1 of 1

Criteria : Item ID: d5383-1 All Locations All Warehouses All Quantity

Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt	Lot Code	Type Code	Comments
D5383-1 Tee	Main Warehouse ST166	151827	2/22/2017	15.0000		QC21		163130
Total:				15.0000				

Linda Lacelle

From: Jean-Luc Menard
Sent: Thursday, June 22, 2017 7:50 AM
To: Patrick Duval; Linda Lacelle
Cc: Mario Poulin
Subject: RE: ECN17-588

D5383-1's?

Yes, we can do them on the 5 axis.
JL

From: Patrick Duval
Sent: Thursday, June 22, 2017 7:47 AM
To: Linda Lacelle <llacelle@dartaero.com>; Jean-Luc Menard <jmenard@dartaero.com>
Cc: Mario Poulin <mpoulin@dartaero.com>
Subject: RE: ECN17-588

JL,

We have qty 15 of D5383-1 in stock but at Rev. A, could does be work to current rev. they will need some holes for the lock wire.

Pat. D.

From: Linda Lacelle
Sent: Thursday, June 22, 2017 7:21 AM
To: Patrick Duval <pduval@dartaero.com>
Cc: Mario Poulin <mpoulin@dartaero.com>
Subject: RE: ECN17-588

Hi Pat,
Can't we just pull all the D5383-1's from stock and drill the holes???

From: Patrick Duval
Sent: Wednesday, June 21, 2017 7:50 AM
To: Linda Lacelle <llacelle@dartaero.com>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

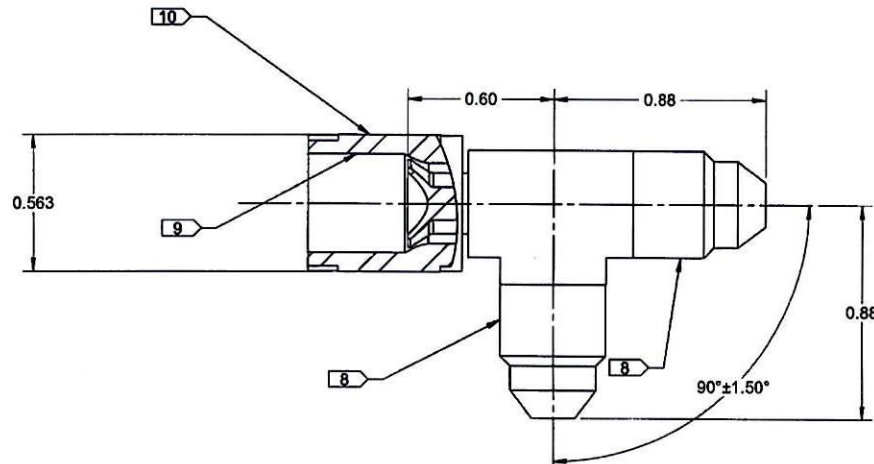
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	Pressure/Forced ☐	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	☐ Offset/Setup	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	☐ Supplier	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	☐ Training	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	☐ Use for Testing	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	☐ Poor Information	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	☐ Rushing	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	☐ Product Improvement	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	☐ Process Improvement	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

SPECIFICATION CONTROL DRAWING



DART P/N	P/N	MATERIAL	WEIGHT (LBS)
△ D5383-1	AS4410J040404L ALT: AS4410J040404	304 STAINLESS	0.09

D5383-1 TEE

- NOTES:**
- 1) MATERIAL: PER TABLE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5383-1" PER DART QSI 044 6.1
 - 7) WEIGHT: 0.09 lbs
 - 8) THREADS SHALL BE 7/16-20UNJF-3A
 - 9) THREADS SHALL BE 7/16-20UNJF-3B
 - 10) FOR THE AS4410J040404, DRILL LOCK-WIRE HOLES PER SHEET 2, DETAIL A △

RELEASED
2016-11-21
ECN 11-675

APPROVED

B	ADDED SHEET 2. ADDED ALTERNATE PART NUMBER	CC	16.11.15
A	NEW ISSUE	CC	16.01.20
REV.	DESCRIPTION	BY	DATE
DESIGN	CC		
DRAWN	CC		
CHECKED	RF		
MFG. APPR.	LL		
APPROVED	HS		
DE APPR.	DS		
DATE	16.11.15		

DART AEROSPACE USA, LTD
EUGENE, OREGON, USA

DRAWING NO. **D5383**

REV. B
SHEET 1 OF 2

SCALE
NTS

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8 7 6 5 4 3 2 1

D

D

C

C

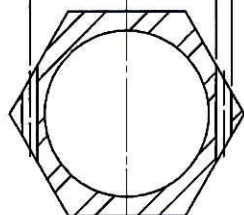
B

B

A

A

0.269±0.005
2 PL



Ø0.042
2 PL

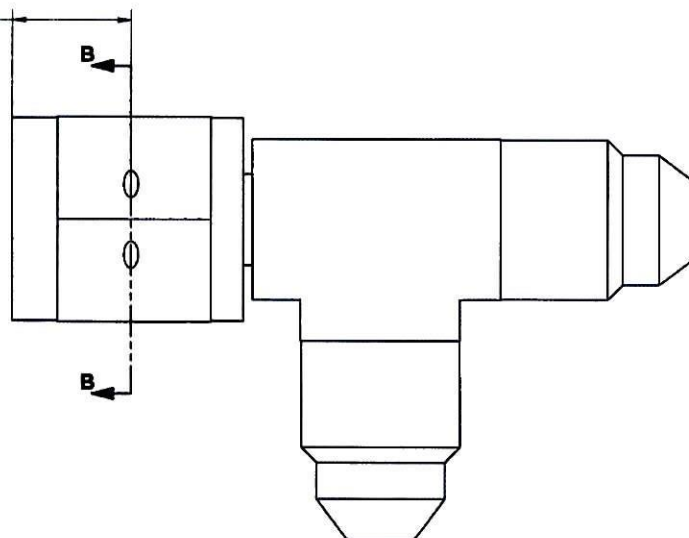
⌀

SECTION B-B

0.328±0.030

B

B



DETAIL A - LOCKWIRE HOLES

RELEASED
2016-11-21

~~RELEASED~~
~~2016-11-31~~

APPROVED

DESIGN	CC	DART AEROSPACE USA, INC.	
DRAWN	CC	EUGENE, OR, USA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	LL	D5383	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	TEE	NTS
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8 7 6 5 4 3 2 1